

## ABSTRACT OF THE DISCLOSURE

A laser machining apparatus capable of changing a laser output condition at a desired machining position and time without regard to an interpolation period. When the remaining motion command amount  $P_a$  in the former of successive blocks, used for the interpolation period  $Q_0$  between these blocks, is less than a motion command amount corresponding to a command speed in the interpolation period ITP, such deficiency  $P_b$  is supplemented by a motion command for the latter block, thus maintaining a moving speed unchanged. The laser output condition is changed between the blocks. A time period  $t_1 = \text{ITP} \times P_a / (P_a + P_b)$  from when the interpolation period  $Q_0$  between the blocks starts to when a change from the former block to the latter is completed is determined. In an interpolation period  $Q_{-1}$ , a CNC sets the time period  $t_1$  and the laser output condition in laser output control signal generating means which changes the laser output condition when the time period  $t_1$  has elapsed from the start of the interpolation period  $Q_0$ , making it possible to change the laser output condition at an arbitrary time without being limited by the interpolation period, whereby a highly accurate laser machining can be achieved.